

Date: Thursday, 26/06/2008 12:34:55 PM  
User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY  
Job Number : 40122  
Estimate Number : 13280  
P.O. Number :  
This Issue : 26/06/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D3674041  
First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D3674 REV A  
Previous Run : 38788 Project Number : N/A  
Drawing Revision : A  
Material :  
Due Date : 03/07/2008 Qty: 30 Um: Each  
Written By : JLM 08-06-27  
Checked & Approved By :  
Comment : Est Rev: A New Issue 08-04-25 JLM Verified By: DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M174B1000X02000 1.250 x 2.00 17-4 SS Bar



Comment: Qty.: 0.5775 f(s)/Unit Total: 17.3250 f(s)

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1.000x02.000) 1.250" x 2.00"

Identify for D3121-111

Batch: M109457

NO MATR IN COMPUTER

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: (1.000" x 2.000") 5.400" long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3674-1 as per Folio FA732 and Dwg D3674 Identify as D3674-1

2-Deburr

3-Scribe batch number

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE





User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 40122

Part Number: D3674041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

25 08/10/06 (3)

6.0

D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-21

Bolt

B40284

08/10/06

7.0

D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-241 Bearing Ass

B39948

08/10/06

8.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble D3121-141 as per Dwg D3121.

08/10/06 (3x)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/06 (x3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

08/10/06 (3)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/06

Job Completion



08/10/06





<b>DART AÉROSPACE LTD</b>		<b>Work Order:</b> 40122
<b>Description:</b> roller bracket		<b>Part Number:</b> D3764-041
<b>Inspection Dwg:</b>	<b>Rev:</b>	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

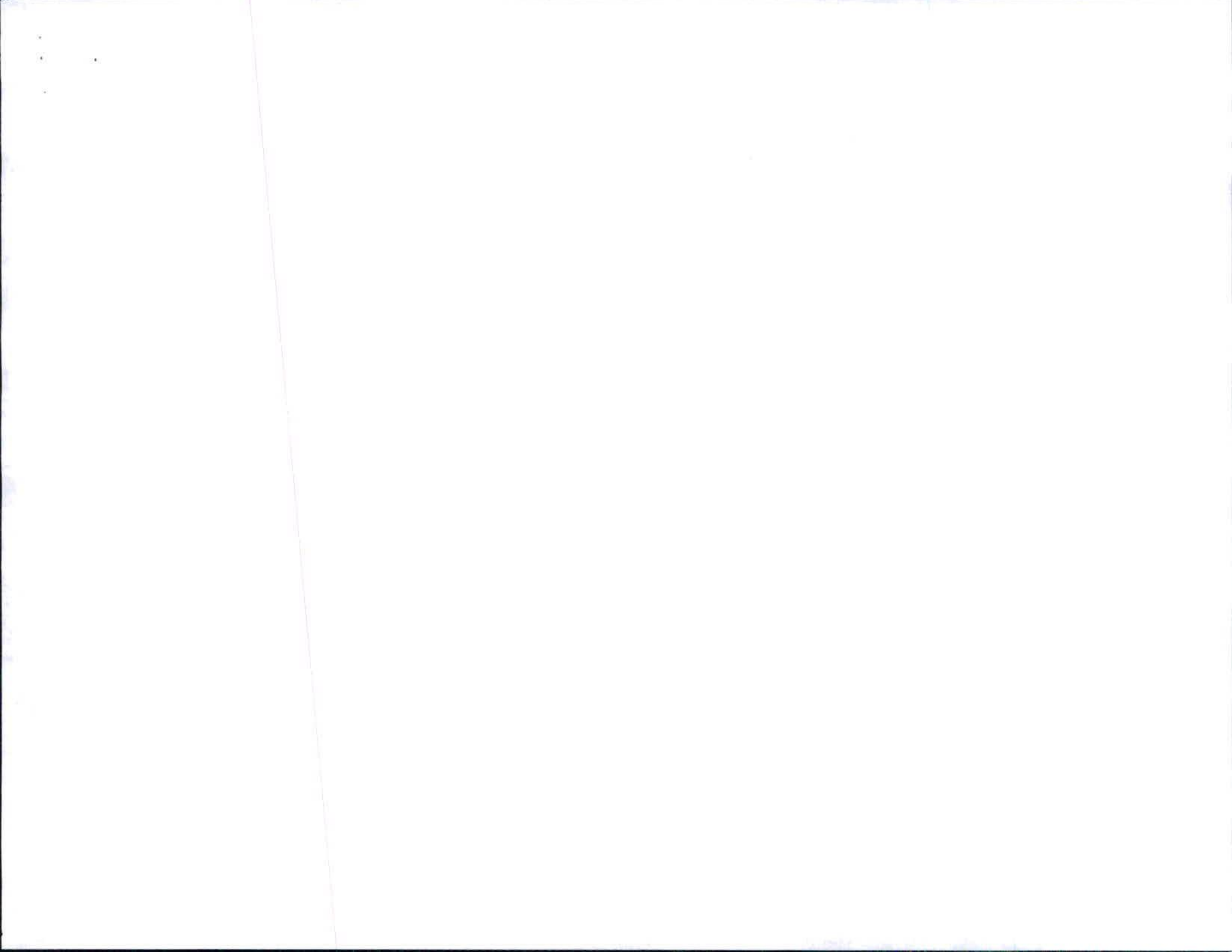
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.960	$\pm .010$	1.965	✓			
.750	$\pm .010$	.750	✓			
.605	$\pm .010$	.607	✓			
3.380	$\pm .010$	3.380	✓			
2.430	$\pm .010$	2.430	✓			
.380	$\pm .010$	.380	✓			
3°	$\pm 1/2^\circ$	3°	✓			
.950	$\pm .010$	.951	✓			
2.030	$\pm .010$	2.033	✓			
2.140	$\pm .010$	2.142	✓			
.720	$\pm .010$	.718	✓			
.573	$\pm .010$	.573	✓			
.392	$\pm .002$	.3928	✓			
.300	$\pm .010$	.299	✓			
.080	$\pm .010$	.079	✓			
5.25	$\pm .030$	5.250	✓			
4.590	$\pm .010$	4.584	✓			
.130	$\pm .010$	.131	✓			
.076	$\pm .010$	.073	✓			
.200	$\pm .010$	.200	✓			
.032	$\pm .010$	.028	✓			
Ø .201 x 100d	$\pm .010$					

<b>Measured by:</b> J.L.
<b>Date:</b> 08/10/05

<b>Audited by:</b> SS
<b>Date:</b> 08/10/06

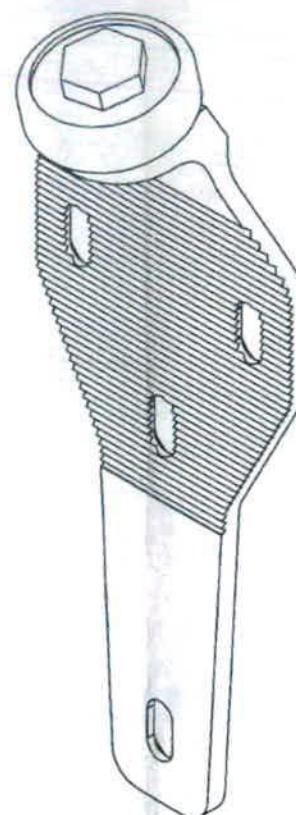
<b>Prototype Approval:</b> N/A
<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





QTY -041	PART NUMBER	DESCRIPTION
X	D3674-041	ROLLER BRACKET ASSEMBLY
1	D3121-21	BOLT
1	D3121-241	BEARING ASSEMBLY
1	D3674-1	BRACKET



**D3674-041 BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs
- 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

**REFERENCE ONLY**

**RELEASED**  
08.06.26

A	NEW ISSUE	AJS	08.03.26
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3674	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ROLLER BRACKET ASSEMBLY	NTS
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D3674-1 BRACKET

D3674-041 BRACKET ASSEMBLY

8  
D3121-21 BOLT

D3121-241 BEARING ASSEMBLY

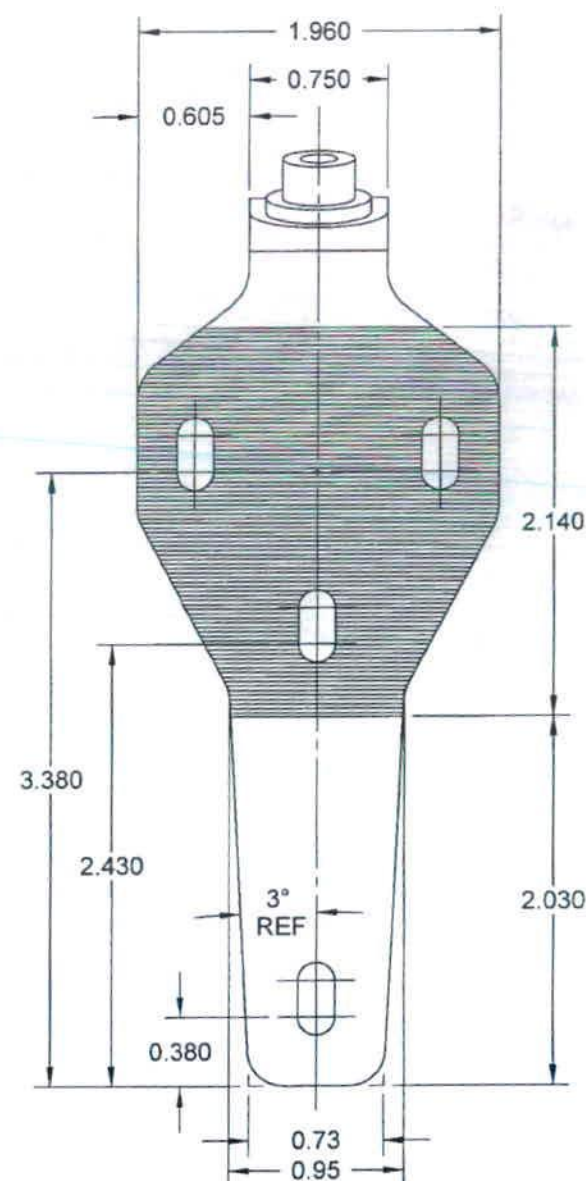
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08-08-26

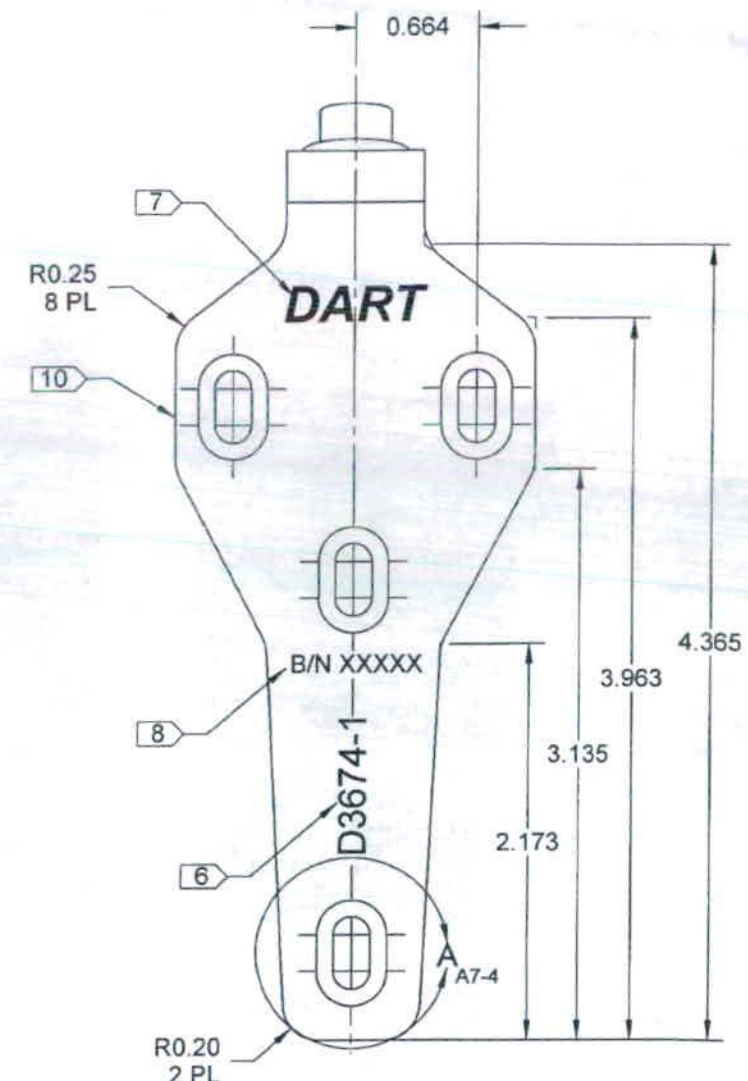
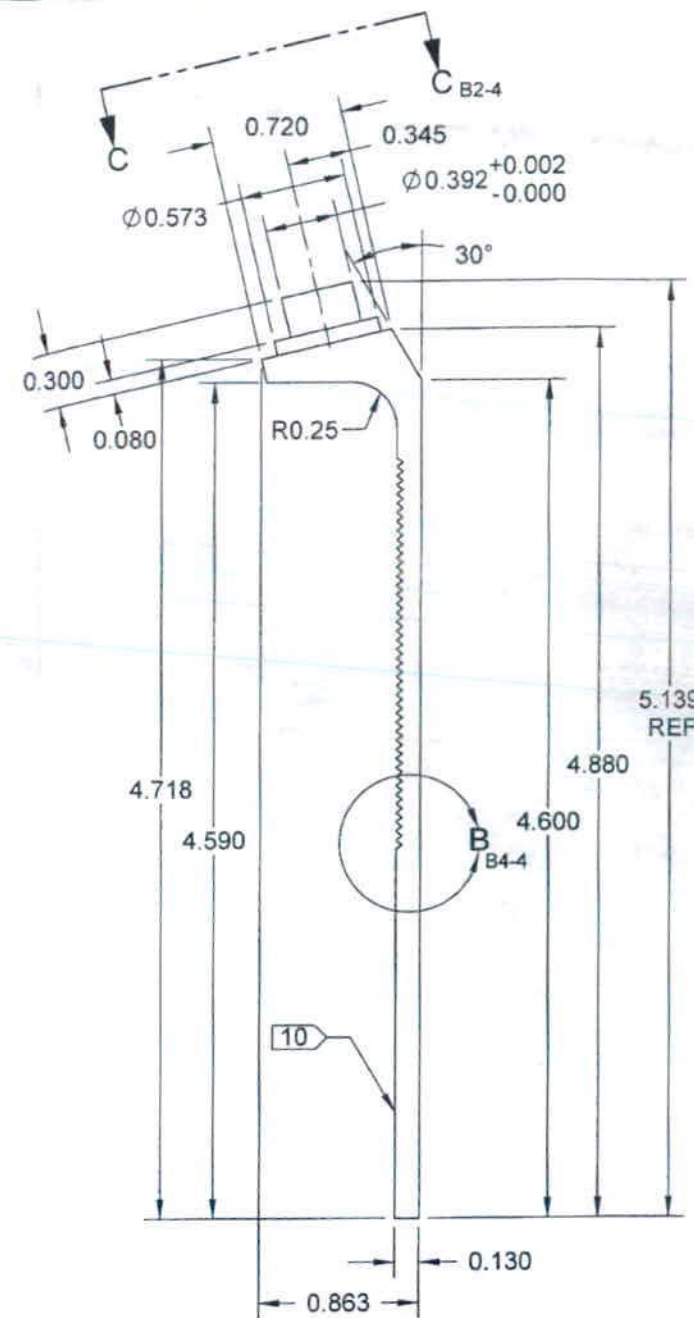
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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3674</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
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**D3674-1 BRACKET**



REFERENCE ONLY

**NOTES:**

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR  
PER AMS 5604/5643  
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET  
MINIMUM YIELD TENSILE STRENGTH = 100 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi  
(REF. DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-1" WITH 0.15 HIGH LETTERS TO A  
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: ENGRAVE DART LOGO WITH 0.20 HIGH LETTER TO A  
MAXIMUM DEPTH OF 0.010 IN AREA SHOWN
- 8) IDENTIFICATION: SCRIBE DART B/N USING VIBRATING STYLUS
- 9) WEIGHT: 0.03 lbs
- 10) BASIC PROFILE OF D3674-1 BRACKET TAKEN FROM D3121-141 REF.

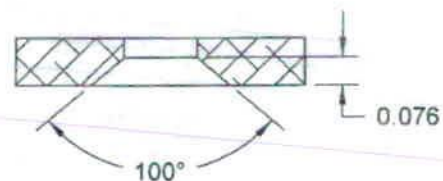
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	APS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3674	SHEET 3 OF 4
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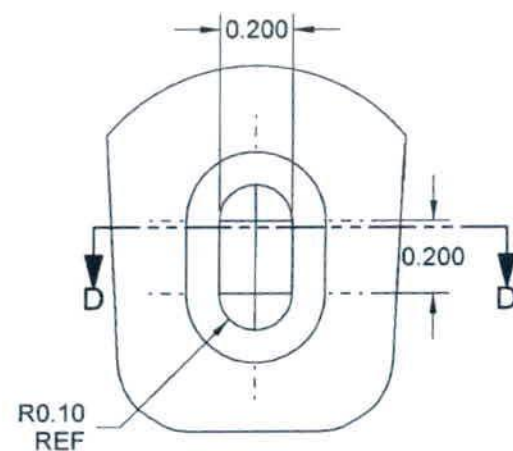
40122-1



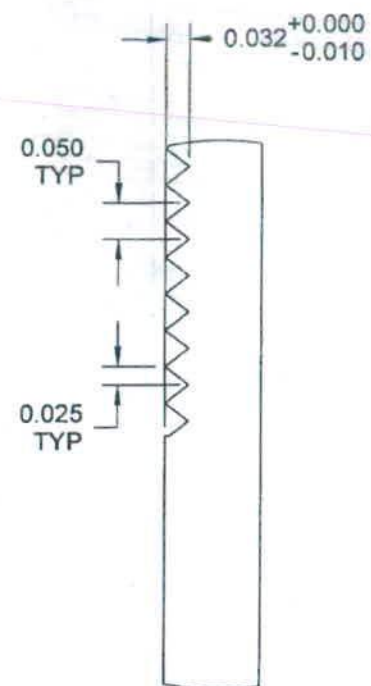




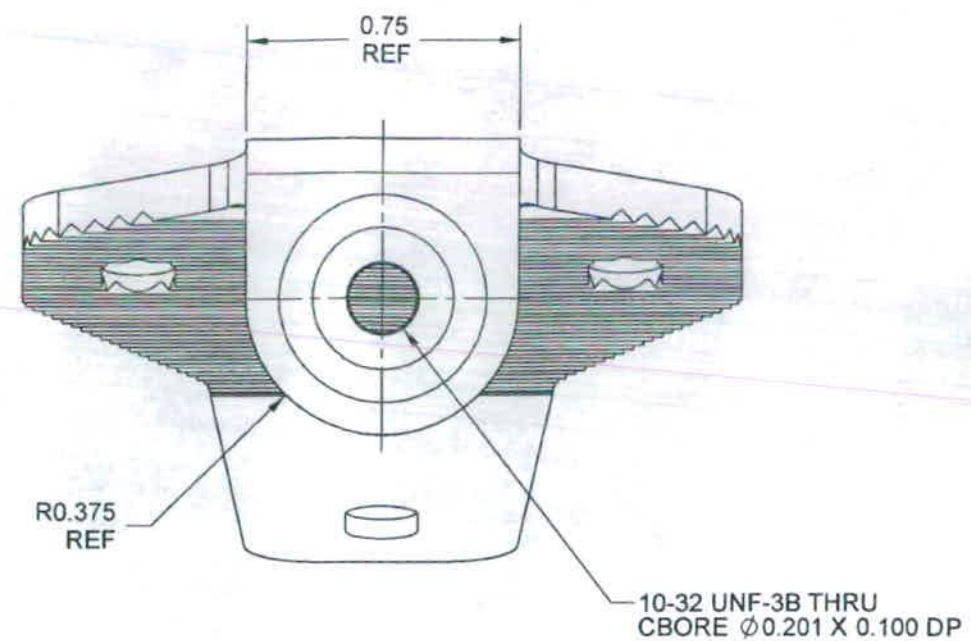
SECTION D-D



DETAIL A B2-3  
SCALE 2X  
(SLOT DETAIL 4PL)



DETAIL B C4-3  
SCALE 4X  
(RIDGE DETAIL)



VIEW C-C D3-3  
SCALE 2X

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40122-1

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